

Date: Wednesday, 30/07/2008 5:28:22 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT, RH
Job Number :	40814		
Estimate Number :	13463		
P.O. Number :		Part Number :	D412769042
This Issue :	30/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN412-769 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	40813	Drawing Revision :	B
	Type :	Material :	
	SMALL / MED FAB	Due Date :	22/08/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>NO 08.7.31</u>		
Comment :	Est rev A 08-07-17 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-769-042 CHG 001

2.0	D412769044	Aft Facing Seat Assembly, RH
-----	------------	------------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Facing Seat Assembly, RH

batch:

40826

AS 08/08/29

3.0	D412724041	Head Rest Assembly, Center
-----	------------	----------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, Center

batch:

41253 x1

AS 08/08/29 (x1)

4.0	D412724044	Head Rest Assembly, RH
-----	------------	------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, RH

batch:

40819 x1

New Batch

AS 08/08/29 (x1)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------

**Comment:** INSPECT 100% KITS FOR COMPLETENESS

S 08/08/29 (x1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:28:22 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT, RH

Job Number: 40814

Part Number: D412769042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-042

Location: _____

PPP Rev: _____

Draft

DS 08/08/29 K1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

DS 08/08/29

Job Completion



MF 08-08-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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Revision: **B**
Date: 08.06.24

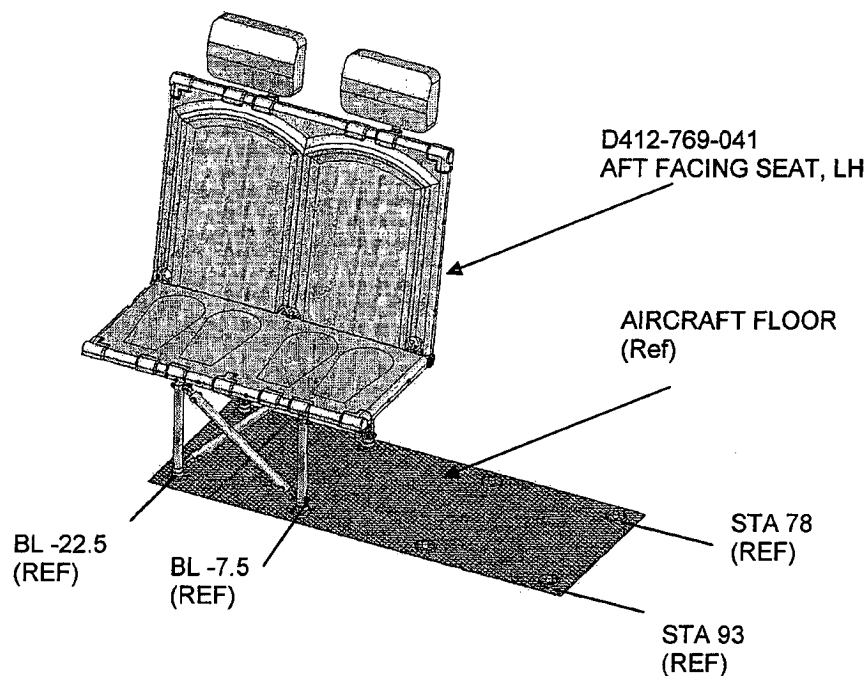


FIGURE 3: D412-769-041 Aft Facing Seat, LH
(LH Installation)

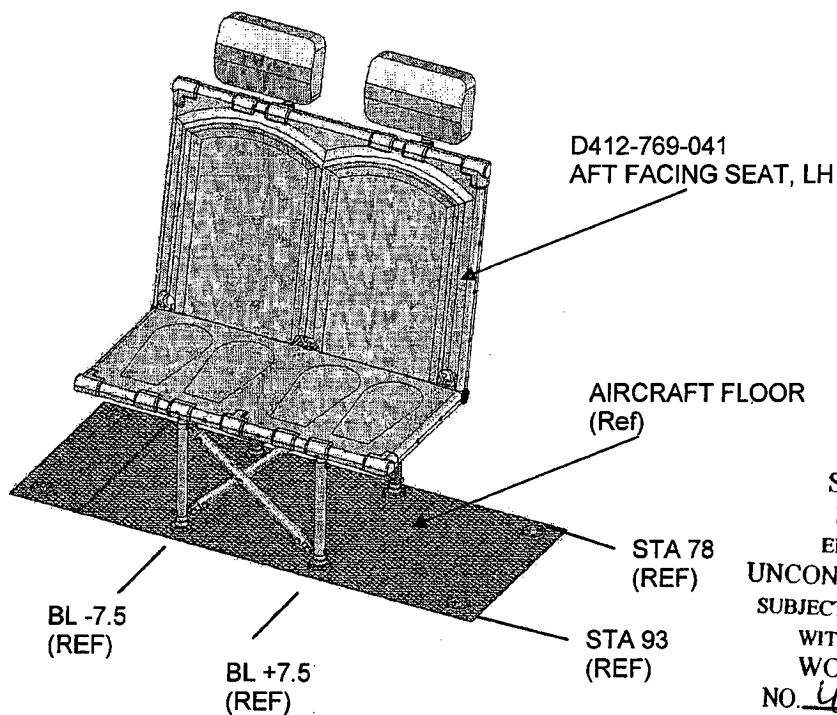


FIGURE 4: D412-769-041 Aft Facing Seat, LH
(Center Installation)

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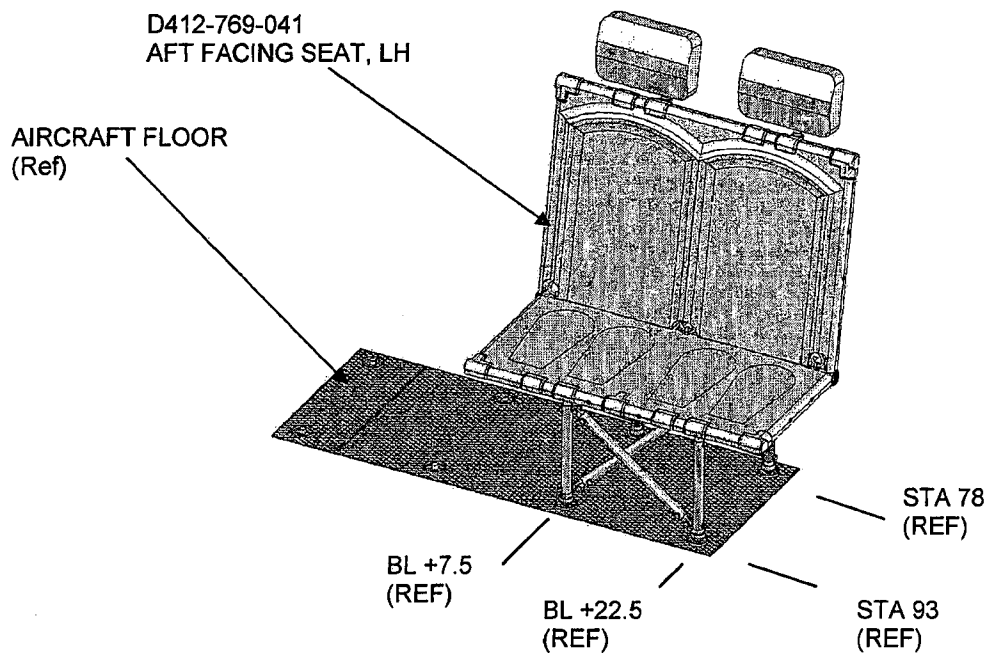


FIGURE 5: D412-769-041 Aft Facing Seat, LH (RH Installation)

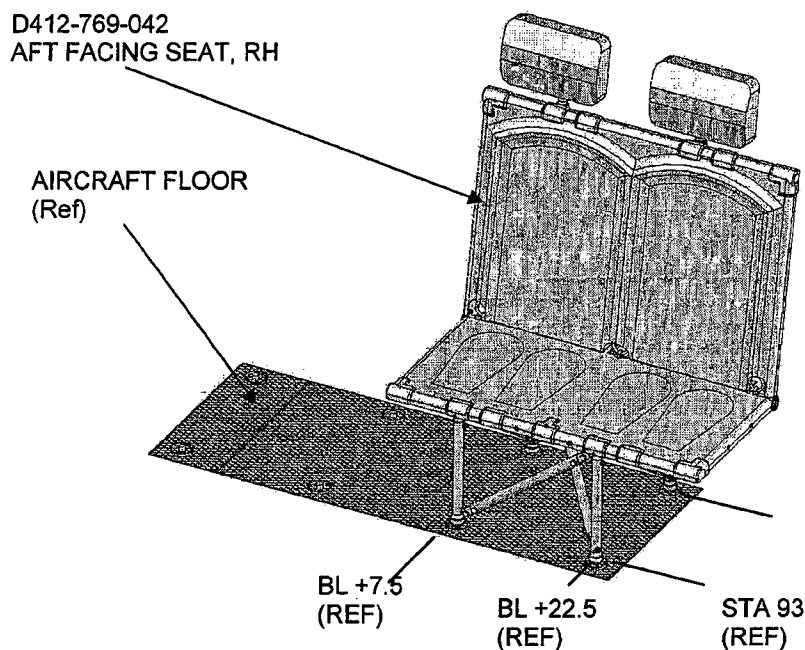


FIGURE 6: D412-769-042 Aft Facing Seat, RH (RH Installation)

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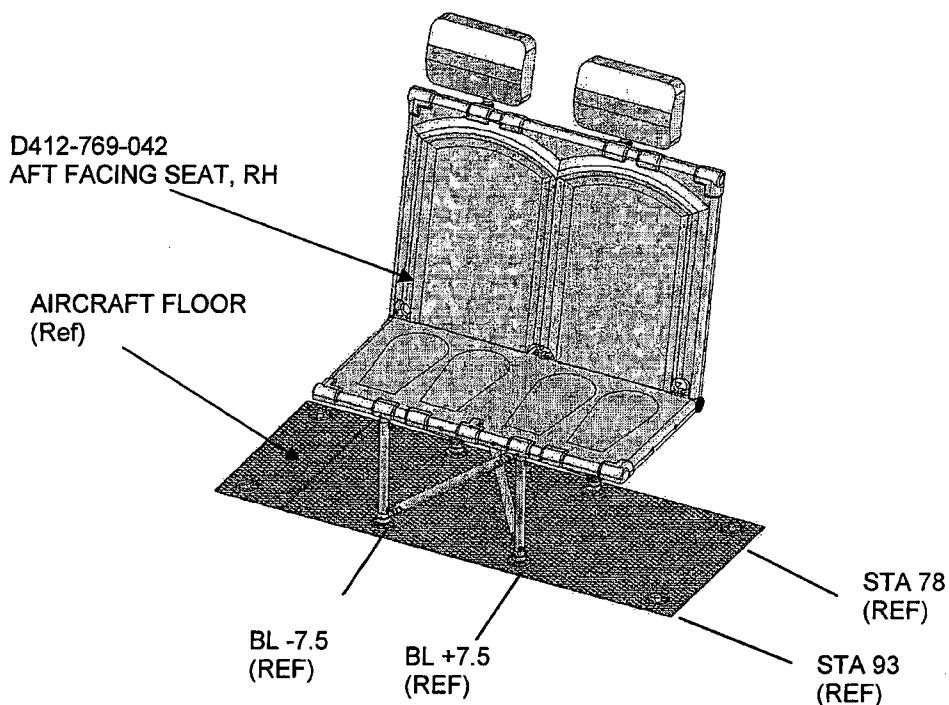


FIGURE 7: D412-769-042 Aft Facing Seat, RH
(Center Installation)

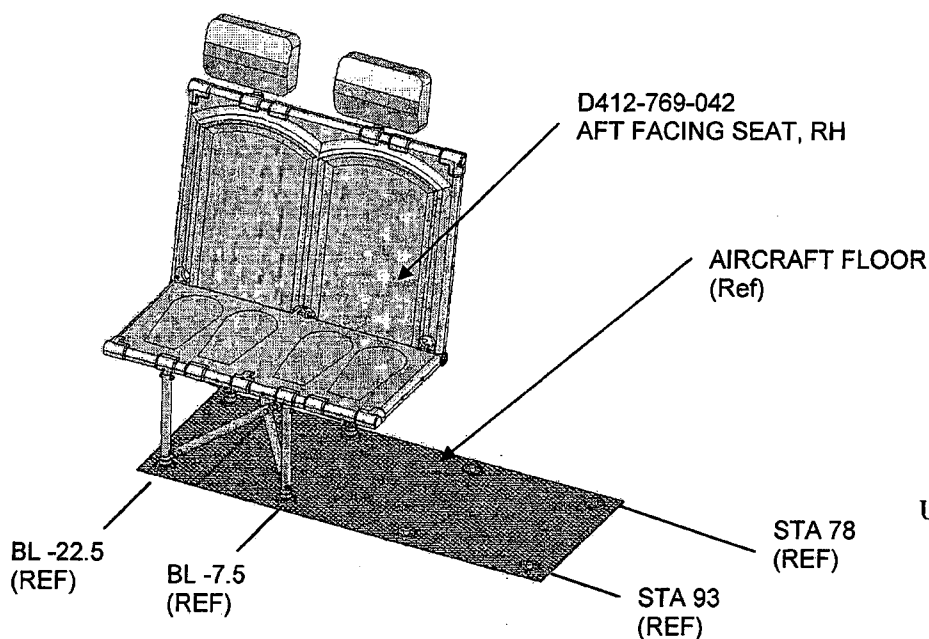


FIGURE 8: D412-769-042 Aft Facing Seat, RH
(LH Installation)

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